

Work Order ID 76931

Thursday, November 24, 2011 8:56:08 AM

76931

Page 1

Item ID: D3372-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Collective Lock Assembly

Stop ***NS2***

Start Date: 11/24/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/25/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 11-11-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3372

Rev B

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372
Identify as D3372-3

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

120

0.00

120

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and
lock barrel. Discard the rest.
2-Fabricate D3369-5 spacer using the flat cam as per Dwg D3369 Identify as
D3369-5

UNALIKE

SB 11/11/24

SB 11/11/25

SB 11/11/25

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, November 24, 2011 8:56:07 AM

Page 1

Work Order ID: 76931

Parent Item: D3372-041

Parent Item Name: Collective Lock Assembly

Start Date: 11/24/2011

Required Date: 11/25/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-13 JLM
 IPP Rev:B Added Key ID 06.03.21 EC
 10.05.13 verified :EC
 IPP Rev:C added D3384-043 DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| 5/16WC SS Flat Washer 5/16 FW516S1 | | Purchased | No | | | 100 | Each | 681.0000 | 2 | 2 | | 11/16/25 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST377 | | 681 | | | | | | | |
| | | | | 117332 | | 87 | | | | | | | |
| | | | | 119343 | | 594 | | | | | | | |
| AN5-42A Bolt | | Purchased | No | | | 100 | Each | 37.0000 | 1 | 1 | | 11/16/25 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST340 | | 37 | | | | | | | |
| | | | | 108442 | | 17 | | | | | | | |
| | | | | 119438 | | 10 | | | | | | | |
| | | | | 119449 | | 10 | | | | | | | |
| AN960-416 Washer | NAS1149F0463P | Purchased | No | | | 100 | Each | 0.0000 | 2 | 2 | | 11/16/25 | |
| D2728-7 Dart Logo label | | Manufactured | No | | | 100 | Each | 0.0000 | 0 | 0 | | | |
| D3372-1 Main Body | | Manufactured | No | | | 100 | Each | 11.0000 | 1 | 1 | | 11/16/25 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST485 | | 3 | | | | | | | |
| | | | | 75126 | | 3 | | | | | | | |
| | | | | ST491 | | 8 | | | | | | | |
| | | | | 75202 | | 8 | | | | | | | |
| D3372-5 Cam Lock Shaft | | Manufactured | No | | | 100 | Each | 8.0000 | 1 | 1 | | 11/16/25 | |
| | | | | <u>Location</u> | | <u>Loc Qty</u> | | <u>Loc Code</u> | | | | | |
| | | | | ST048 | | 8 | | | | | | | |
| | | | | 76485 | | 8 | | | | | | | |

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NOTE: Date & initial all entries

Picklist Print

Thursday, November 24, 2011 8:56:08 AM

Page 2

Work Order ID: 76931

Parent Item: D3372-041

Start Date: 11/24/2011

Required Date: 11/25/2011

Parent Item Name: Collective Lock Assembly

Start Qty: 1.00

Required Qty: 1.00

D3372-7
Slider Body

Manufactured No

100 Each 0.0000

1

1 11/11/25

D3373-1
Cam Lock

Manufactured No

100 Each 72.0000

1

1 11/11/25

Location

Loc Qty

Loc Code

ST049

72

58463

2

74862

20

75666

50

D3384-043
Cyclic Sock Assembly

Manufactured No

100 Each 4.0000

1

1 11/11/25

Location

Loc Qty

Loc Code

ST480

3

74729

3

ST486

1

70037

1

HX-81
1/4"-20 SHCS 3/8" long

Purchased No

100 Each 10.0000

1

1 11/11/25

Location

Loc Qty

Loc Code

ST390

10

114383

10

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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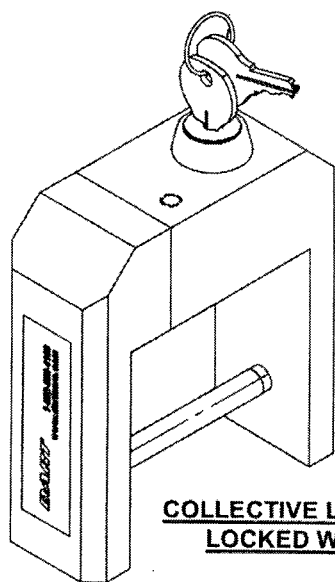
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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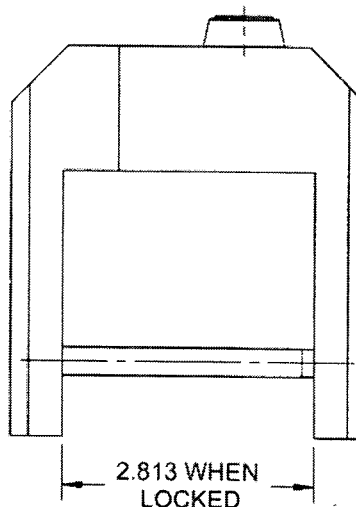
NOTE: Date & initial all entries



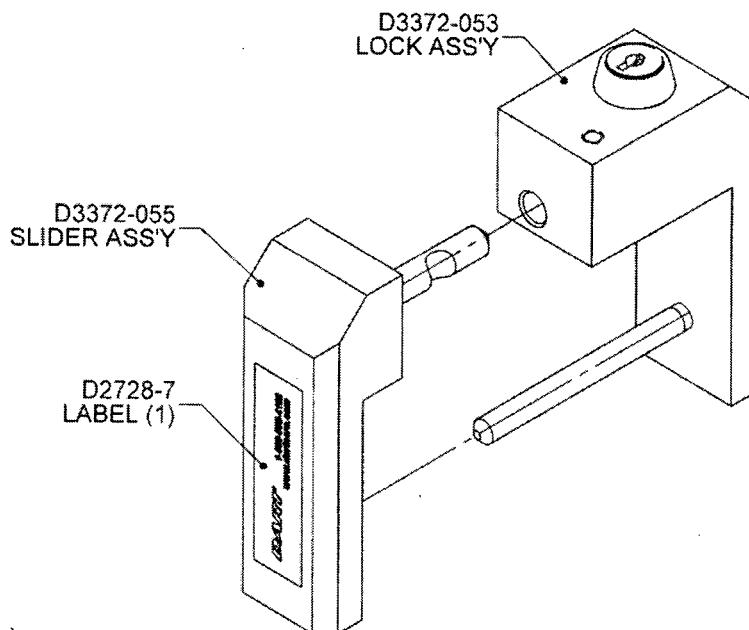
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| CHECKED | APPROVED | DRAWING NO. D3372 | REV. B SHEET 1 OF 8 |
| DATE | 05.02.23 | TITLE COLLECTIVE LOCK | SCALE 1:2 |
| A | 05.01.10 | NEW ISSUE | |
| B | 05.02.23 | REDESIGN FOR STANDARD 1/4 TURN LOCK, D3369-5 SUPERCEDES D3372-11 (OBSOLETE) | |



**COLLECTIVE LOCK SHOWN
LOCKED WITH KEYS**



2.813 WHEN
LOCKED



RELEASED
05/04/28

76931

D3372-051 AS350 COLLECTIVE LOCK ASS'Y

NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES

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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

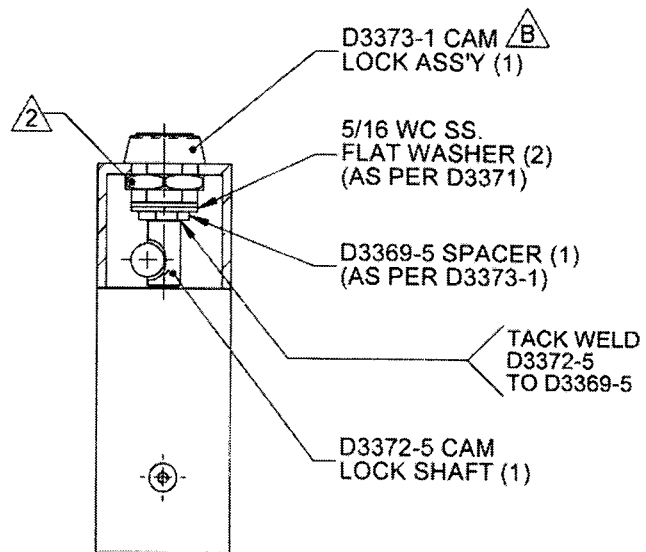
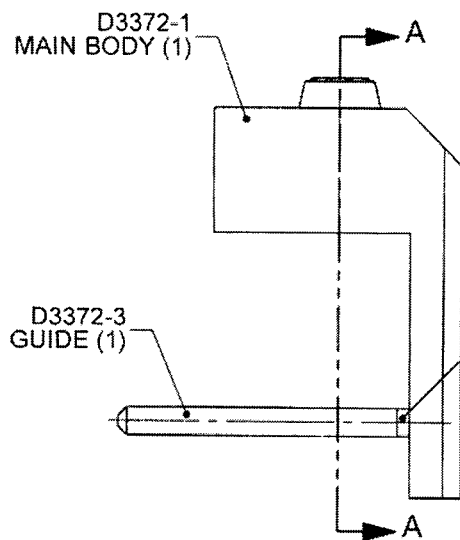
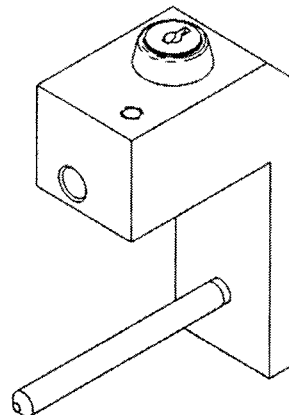
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NOTE: Date & initial all entries



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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3372 | REV. B SHEET 2 OF 8 |
| DATE 05.02.23 | | TITLE COLLECTIVE LOCK | SCALE 1:2 |

RELEASED
[Signature]
05/04/23



SECTION A-A

D3372-053 LOCK ASS'Y

NOTES:

- 1) WELD PER DART QSI 004
- 2) APPLY THREADLOCKER LOCTITE 262 ON THREADS

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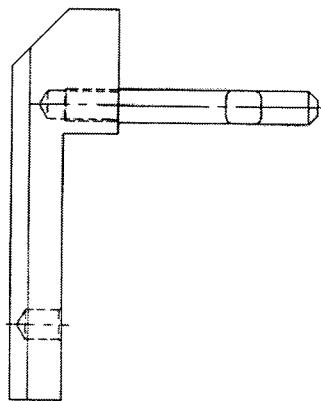
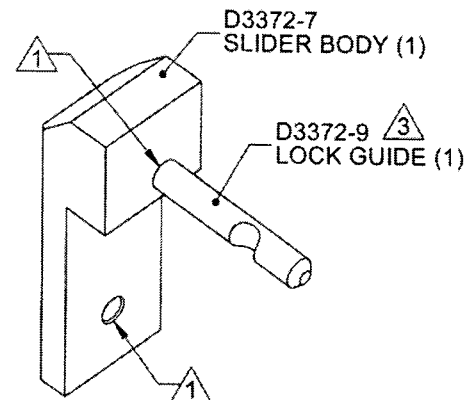
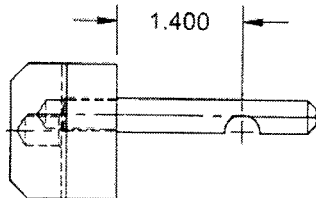
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NOTE: Date & initial all entries



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| DATE 05.02.23 | | TITLE COLLECTIVE LOCK | SCALE 1:2 |

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[Signature]
05/04/23



#7693

D3372-055 SLIDER ASS'Y

NOTES:

- 1) COVER INSIDE HOLES AND D3372-9 PRIOR PAINTING
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) APPLY THREADLOCKER LOCTITE 262 ON D3372-9 THREADS PRIOR ASSEMBLY
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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| W/O: | | WORK ORDER CHANGES | | | | | |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

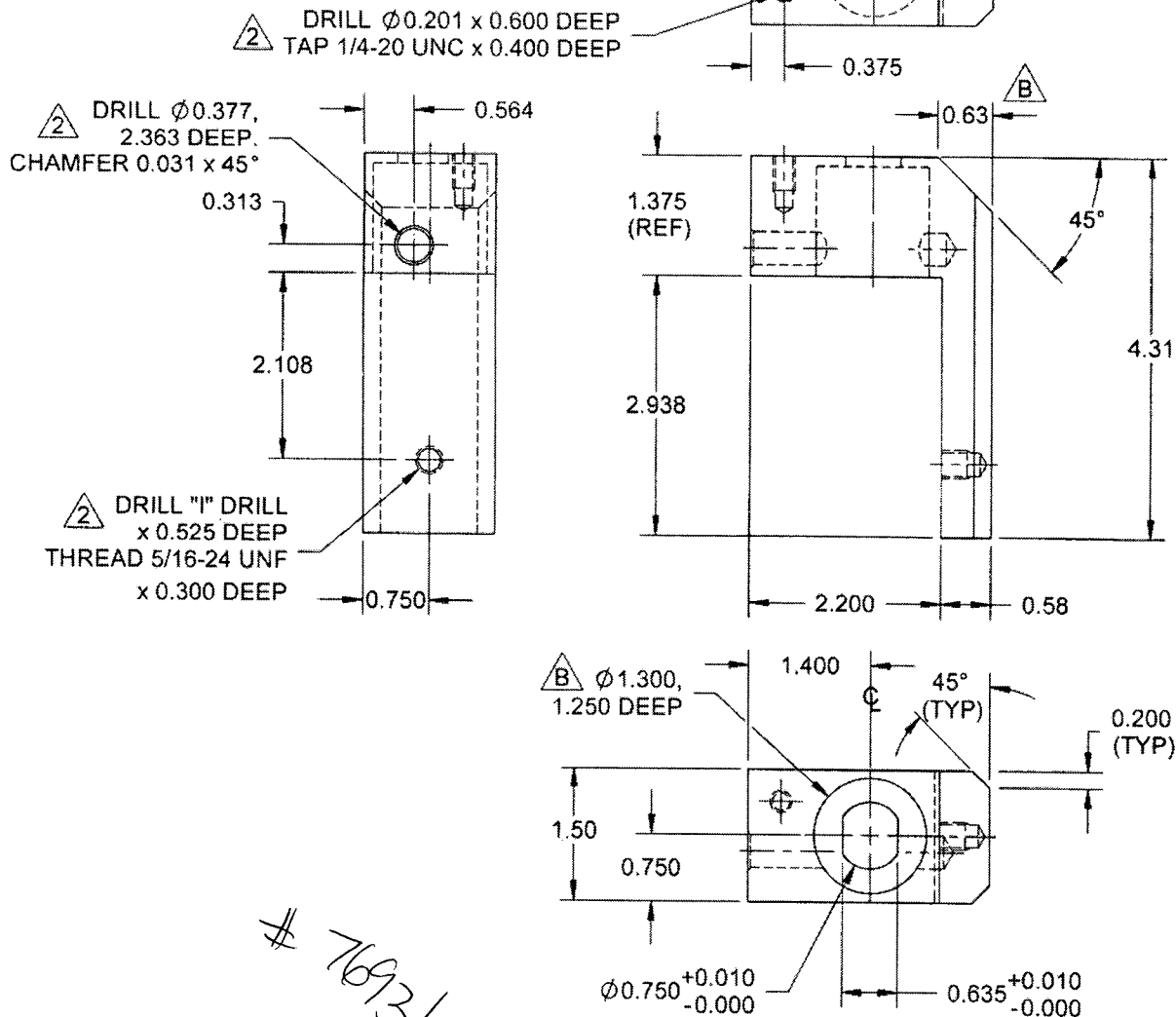
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NOTE: Date & initial all entries



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| DESIGN B | DRAWN BY B | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED H | APPROVED B | DRAWING NO. D3372 | REV. B SHEET 4 OF 8 |
| DATE 05.02.23 | | TITLE COLLECTIVE LOCK | SCALE 1:2 |

RELEASED
05/04/23



D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) COVER INSIDE HOLES PRIOR PAINTING
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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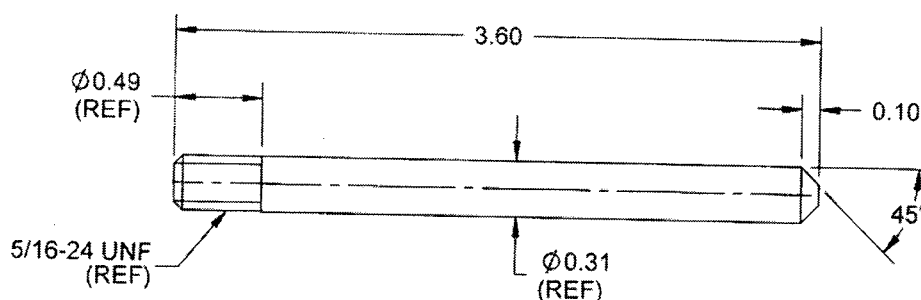
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| DATE 05.02.23 | | TITLE COLLECTIVE LOCK | SCALE 1:1 |

SPECIFICATION CONTROL DRAWING

RELEASED
[Signature]
05/04/23



76931

D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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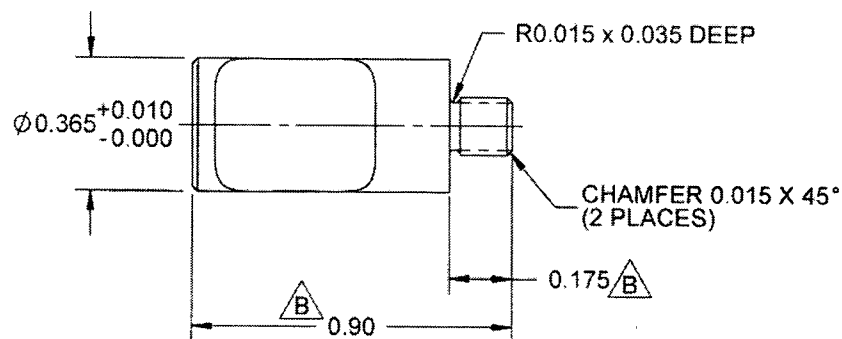
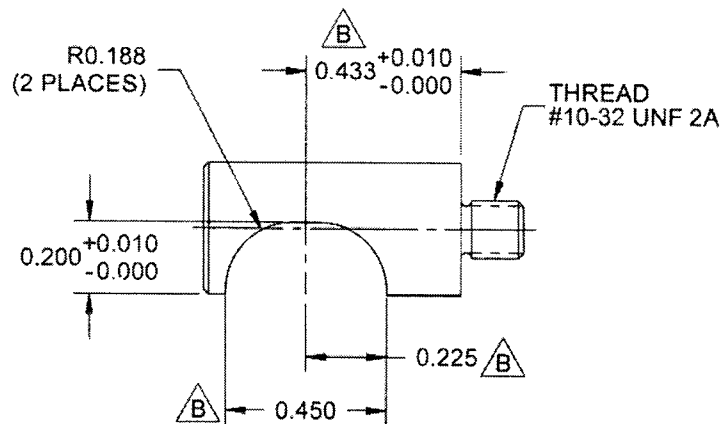
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NOTE: Date & initial all entries



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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3372 | REV. B SHEET 6 OF 8 |
| DATE 05.02.23 | | TITLE COLLECTIVE LOCK | SCALE 2:1 |

RELEASED
[Signature]
05/04/28



#7693)

D3372-5 CAM LOCK SHAFT

NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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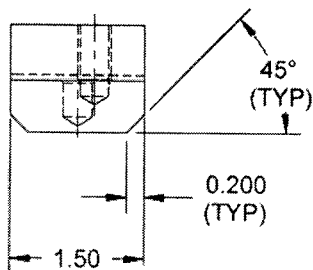
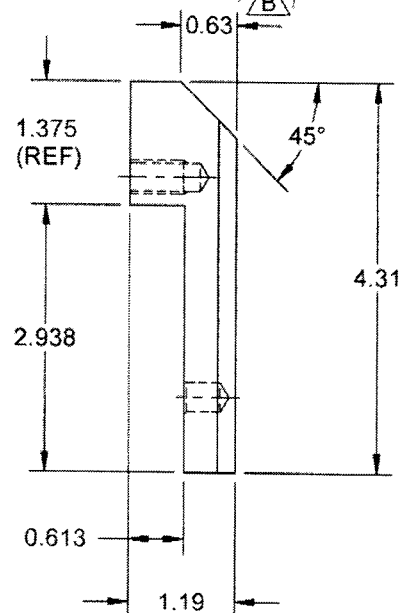
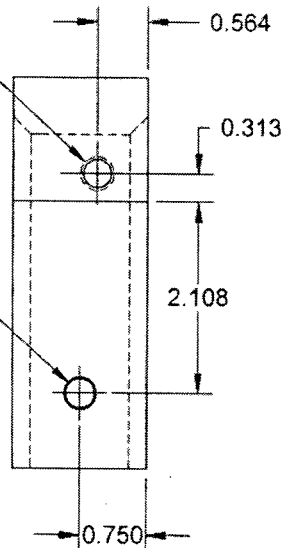
NOTE: Date & initial all entries



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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3372 | REV. B SHEET 7 OF 8 |
| DATE 05.02.23 | | TITLE COLLECTIVE LOCK | SCALE 1:2 |

DRILL $\varnothing 0.332$
("Q" DRILL) x 0.881 DEEP,
THREAD 3/8-24 UNF x 0.600 DEEP

DRILL $\varnothing 0.323$
("P" DRILL) x 0.500 DEEP
CHAMFER 0.030 x 30°



76931

D3372-7 SLIDER BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

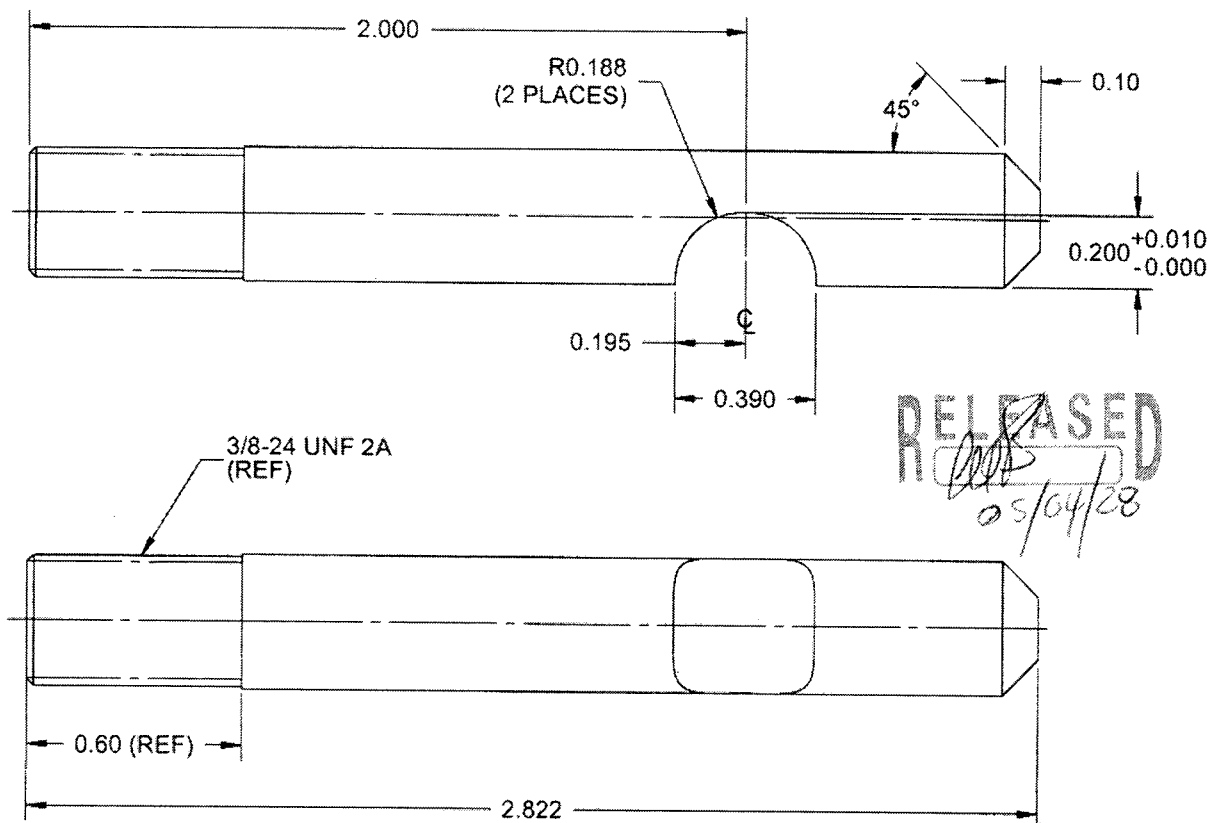
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3372 | REV. B SHEET 8 OF 8 |
| DATE 05.02.23 | | TITLE COLLECTIVE LOCK | SCALE 2:1 |

SPECIFICATION CONTROL DRAWING



7693)

D3372-9 LOCK GUIDE

NOTES:

- 1) MATERIAL: AN6-36A BOLT, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

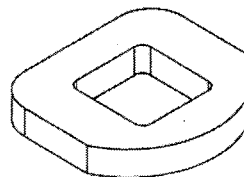
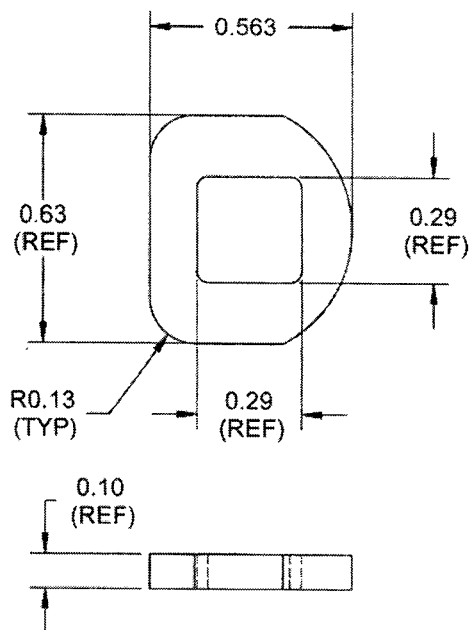
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3369 | REV. A SHEET 4 OF 4 |
| DATE 04.12.16 | | TITLE BATTERY LOCK | SCALE 2:1 |

SPECIFICATION CONTROL DRAWING



RELEASED
[Signature]

05/02/11

C2111124

W/D. 76931

-5
D3369 SPACER



NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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